

5/14

DART AEROSPACE LTD	Work Order:	22636
Description: Doubler	Part Number:	D3248-1
Dwg: D3248 Rev. A	Qty:	40
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JA	05.03.09	40
2	PG	Issue P/O: <u>2007/92</u> Fabricate D3248-1 as per Dwg D3248 Possible Supplier: Industrial Laser Material release note is required	W	05.07.11	40
3	RG	Receive and inspect for transit damage Ensure material release note is attached	CL	05/06/08	45
4	QC6	Inspect dimensions as per Dwg D3248	Z	05.06.13	45
5	GA	Deburr	me	05-07-06	45
5A		DRILL HOLES 0.128 AS REQUIRE / 0.257 Tor	me	05-07-06	45
6	QC5	Inspect work to Step 5	Z	05-07-11	45
7	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05.07-14	45
8	QC3	Inspect Chemical Conversion Coat	M	05.07.14	45
9	ST	Identify and Stock	Z	05-07-14	45
10	AC	Cost / part:			
11	DC	Close W/O Inspect Level 21	FB	05/07/26	45

Rev	Date	Change	Revised By	Approved
A	04.05.25	New issue	KJ/JLM	
B	04.10.26	D3248-1 no longer made in-house	KJ/JLM	

Before deburring
drill holes to
Size ^{0.128} AS per
dwg 3248

Traveler ?
2205-579-015
B22636

RELEASED
10/10/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

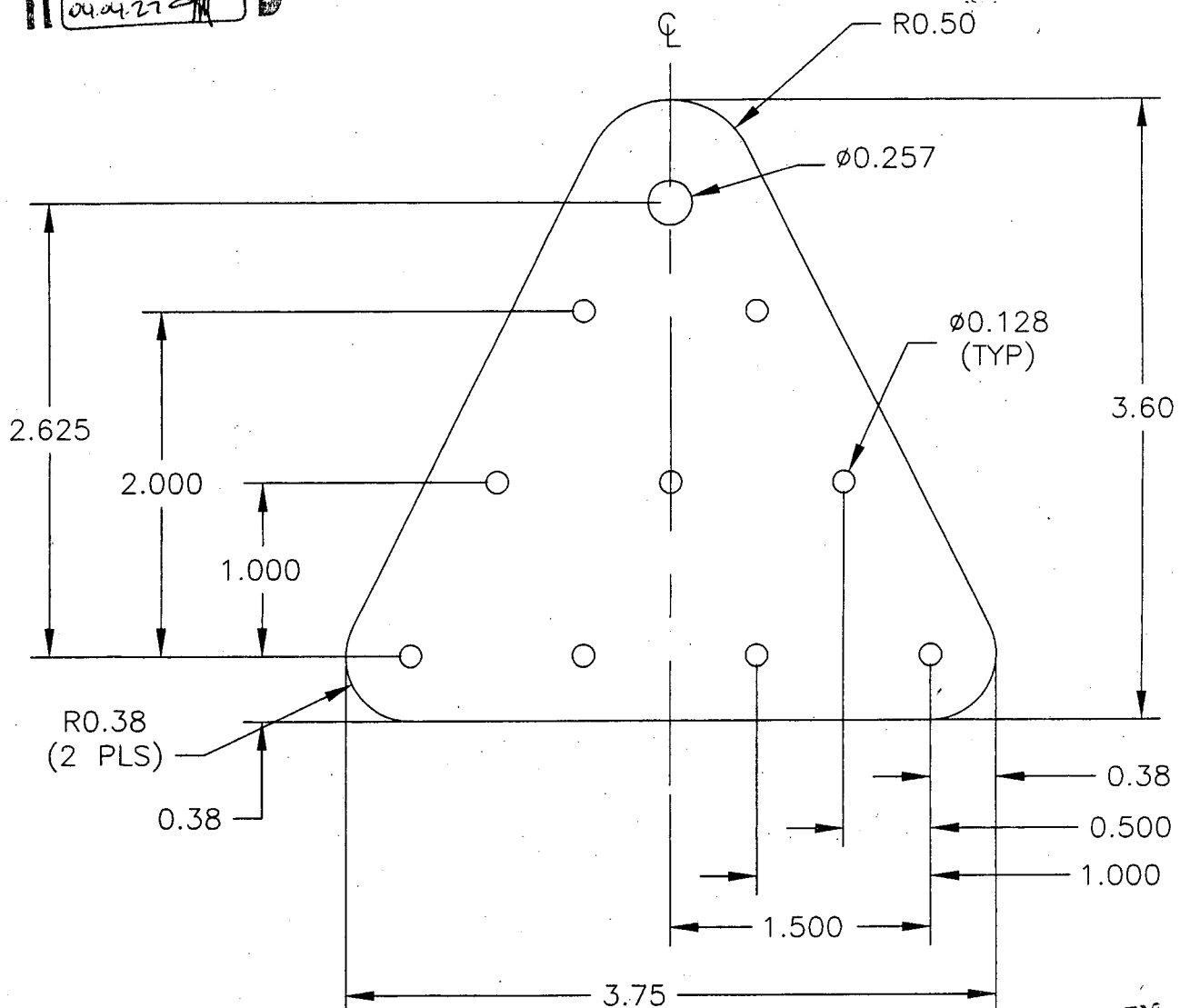
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED H	DRAWING NO. D3248	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE DOUBLER	SCALE 1:1
A	04.04.06	NEW ISSUE	

RELEASED
04.04.27



D3248-1

NOTE:

- 1) MATERIAL: 5052-H32/H34 SHEET (QQ-A-250/8) 0.063 THICK (REF: DART SPEC. M5052H32S.063)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) PART IS SYMMETRIC ABOUT CENTERLINE

SHOP COPY
RETURN TO
ENGINEERING

WORK ORDER
NO. 22636

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INT 56015 O/N 359124

06/02/05 THU 10:15 FAX 604 272 0951
Integris Metals 6/2/2005 11:58

INTEGRIS METALS
PAGE 002/002

fax server

04/01/05 FRI 14:03 FAX 604 272 0951
APR-01-2005 13:46 INTEGRIS METALS

INTEGRIS METALS

MTR MINNEAPOLIS
763 717 7112 P.03/03

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA LAVENTON, VIRGINIA
Ship From: ALABAMA, IA.

Page 2

TOTAL 2.0

The body of this report and the data contained herein are based on the information provided by the customer and the inspection results. The inspection results are based on the information provided by the customer and the inspection results. The inspection results are based on the information provided by the customer and the inspection results.

Handwritten signature
Inspector of Manufacturing Department

Handwritten signature
Quality Assurance Manager

Lot: 758011 - Mechanical, Physical, Metallurgy, Quantitative Results (cont.)
Cast Number: Chemical 81 PE CU NI PG CA ZN TI
Actuals: .87 .13 4.5 .6 1.5 .01 .08 .01

20017
Ship Date: 2005-01-21 Bill No. 67993 Invoice No. 81618 Alcoa No. Item DS-84819-1
P.O. No./Contract No. Customer
419344:20050119 INTEGRIS MTL-COON